

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010006**Date Inspected:** 26-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>			
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG				

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

North of bay 14-

This QA Inspector performed Magnetic Particle Testing (MT) verification of welds previously tested and accepted by ZPMC for OBG Segment 6CW lifting lug welds. The following welds were tested: SSD10B-PP44-221, 227, 237, 236, 241, 257, 253, SSD11-PP45-220, 226, 236, 234, 240, 246, 256 and 252.

This QA Inspector performed Magnetic Particle Testing (MT) verification of welds previously tested and accepted by ZPMC for OBG Segment 6CW floor beam to side panel welds. The following welds were tested: SSD10-PP44-066, 068, 070, 111, 113 and 115.

This QA Inspector performed Magnetic Particle Testing (MT) verification of welds previously tested and accepted by ZPMC for OBG Segment 6CW longitudinal diaphragm welds. The following welds were tested: SEG031D-005, 022, 027, SEG031F-026, 028 and 029. SEG31F-028 was rejected for a 8mm transverse linear indication. A incident report was issued for the above mentioned indication this date.

This QA Inspector performed Magnetic Particle Testing (MT) verification of welds previously tested and accepted by ZPMC for OBG Segment 6CW angle iron welds at mid panel point. The following welds were tested: SSD30-44.5-011~016, 49~54 and 91~96.

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This QA Inspector performed Magnetic Particle Testing (MT) verification of welds previously tested and accepted by ZPMC for OBG Segment 7BE connecting angle plates. The following welds were tested: SSD18A-PP52-020~027, 070, 072, 074, 259, 258, 249 and 248.

## Blast Shop 1-

This QA Inspector performed Magnetic Particle Testing (MT) verification of welds previously tested and accepted by ZPMC for OBG Segment 6AW deck panel diaphragm to floor beam welds. The following welds were tested: SSD9-PP37-004 and SSD10-PP38-003, 004.

This QA Inspector performed Magnetic Particle Testing (MT) verification of welds previously tested and accepted by ZPMC for OBG Segment 6AW deck panel diaphragm welds. The following welds were tested: DP084-001-037, 047, 055, 059, DP111-001-049, 059, 062, 067, DP165-001-077, 059, 069, 086, DP273-001-056, 051, 048, 038, DP246-001-094, 081, 065, 060 and DP192-001-073, 077, 085. The following welds were rejected by Caltrans QA for crater cracks, DP084-001-059, DP111-001-059, 062, 067, DP165-001-086, DP273-001-056, 051, 048, 038, DP246-001-094, 081, 065, 060. Caltrans QA Inspector issued a Incident report for the above mentioned MT indications. See attached photos for further detail.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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## WELDING INSPECTION REPORT

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### Summary of Conversations:

As identified within the contents of this report.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Viars,Larry	Quality Assurance Inspector
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<b>Reviewed By:</b>	Dawson,Paul	QA Reviewer
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